Work Order ID 125272

125272

Tuesday, October 07, 2014 10:39:59 AM

Item ID: D4839-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Blade

Start Date: 10/15/14 **Start Qty:** 8.00 *8* **Cust Item ID:**

Required Date: 10/15/14 **Req'd Qty:** 8.00 *8* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** M **Date:** 14.10.08 **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D4839 / REV A									
100		0.00							~~DAS~~ 41 9-89
100						8			14-10-10
Packaging	**Memo**	0.00							
Packaging	PULL FROM STOCK: 8 X 646.9711 B 108731								
	RE-IDENTIFY AS D4839-1								
110	QC4- 100% Inspect kits for completeness	0.00							DAS 38 ~~9-89~~ 14-10-10
110						8			
QC	**Memo**	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: MF	0.00							
120						(8)	MLJ	14-10-10	
Packaging	**Memo**	0.00							
Packaging									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
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☐ Set-up
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☐ Weld
☐ Wrong Stock Pulled
☐ Other

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	**Memo**	0.00				_____	14/10/15		
Quality Control									

14.10.15

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Part No. _____

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Scrap	☐
Use-as-is	☐
Suspected Unapproved	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

Wednesday, October 08, 2014 8:50:56 AM

Work Order ID: 125272

125272

Parent Item: D4839-1

D4839-1

Parent Item Name: Blade

Start Date: 10/15/14 **Required Date:** 10/15/14

Start Qty: 8.00 **Required Qty:** 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9711		Manufactured	No				Each	92.0000		8	DAS 41 9-89	14-10-10	
646 9711 Blade									**				

Location	Loc Qty	Loc Code	
MF	92		
100268	13		
104205	8		
106350	2		
108731	89		8
109392	21		
112223	2		
121406	30		
98911	11		

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Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

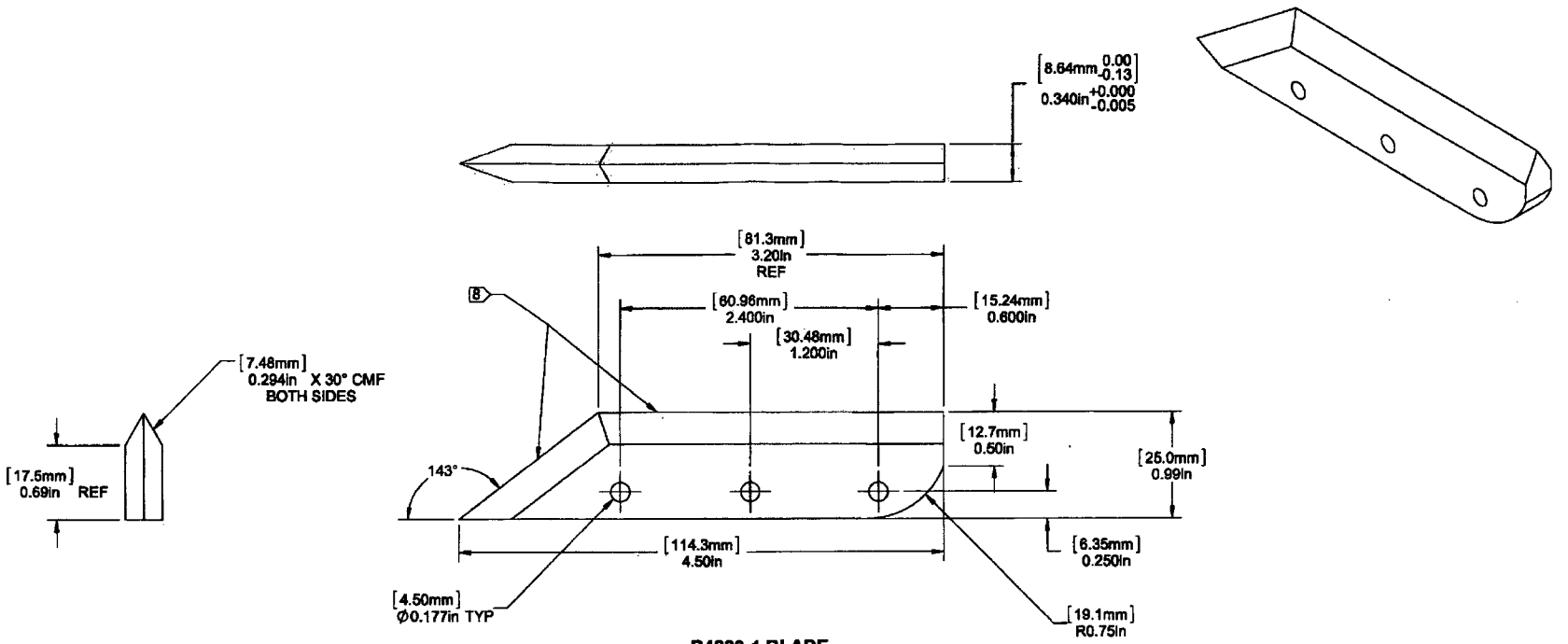
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☐ Set-up
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☐ Weld
☐ Wrong Stock Pulled
☐ Other



D4839-1 BLADE

RELEASED
2013 -07- 12

NOTES:
1) MATERIAL: AISI A2 TOOL STEEL PER ASTM A681 (DART SPEC MSTEEL-A2-B0.375X4.500)
CONDITION: ANNEALED (HEAT TREAT TO 58-62 ROCKWELL C HARDNESS) PER MIL-T-6736 OR AMS2759/1E
2) FINISH: PRIME IAW MIL-P-23377J TYPE1, CLASS N: 1-2 MIL MAX, AS PER QSI 005.
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.28 lbs (0.13 kgs)
8) DO NOT BREAK EDGE OF BLADE, INTENDED TO BE SHARP
9) REFERENCE APICAL PART NUMBER 646.9711

14-10-08
125272

REV.	DESCRIPTION	BY	DATE
A	NEW RELEASE	DB	13.05.23

DESIGN	DB	DART AEROSPACE LTD
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA
CHECKED	A.P.	DRAWING NO. D4839 REV. A
MFG. APPR.		SHEET 1 OF 1
APPROVED		TITLE BLADE SCALE NTS
DE APPR.		
DATE	13.05.23	

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